

BLS/ES

Date: Wednesday, 12/11/2008 1:41:04 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 02.500 SUPPORT		
Job Number	: 43385			Part Number	: D28921	
Estimate Number	: 11058			Drawing Number	: D2892 BLUE	
P.O. Number	:			Project Number	: N/A	
This Issue	: 12/11/2008	S.O. No. :		Drawing Revision	: A	
Prsht Rev.	: NC			Material	:	
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 10/12/2008	Qty: 12 Um: Each
Previous Run	: 42785					
Written By	:					
Checked & Approved By	: <u>JUL 08.11.12</u>					
Comment	: Est. C 02.11.26 Added P/O KJ Est. D 08.03.19 Re-format EC verified by: DD					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DSK077	D2892-1 TURNING DETAIL	
		Comment: Qty.: 0.5000 Each(s)/Unit Total : 6.0000 Each(s) D2892-1 TURNING DETAIL Batch: <u>B42245</u>	<u>JL 08/11/26</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS Machine as per Folio FA082 Tumble & Deburr	<u>JL 08/11/26</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>JL 08/11/26</u>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>24 08/11/26</u>
5.0	SPRAY PAINTING	SPRAY PAINTING	
		Comment: -PRIME B <u>109992</u> -PAINT DELFLEET BLUE <u>B105918</u> -CLEAR DELFLEET B <u>109816</u>	<u>m 08 12 03</u> <u>(12)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:41:04 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.500 SUPPORT

Job Number: 43385

Part Number: D28921

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC14

INSPECT SPRAY PAINT



08-12-04 (12)



Comment: INSPECT SPRAY PAINT

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Crossstokes

08 12 04 (12)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43385
Description: Ø2.500 Support	Part Number:	D2892-1
Inspection Dwg: D2892	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.115	0.135		.132	.132	.132	.132	.132
AB	0.290	0.310		.310	.310	.310	.310	.310
AC	0.040	0.060		.043	.043	.042	.042	.042
AD	0.115	0.135		.127	.126	.126	.127	.126
AE	0.240	0.260		.250	.250	.251	.251	.251
AF	0.188	0.193		.190	.190	.190	.190	.190
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.134	1.133	1.130	1.132	1.139
AI	0.454	0.474		.464	.464	.465	.465	.465
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.261	.261	.261	.261	.261
AM	1.663	1.683		1.672	1.673	1.673	1.673	1.674
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: J-L Date: 08/11/25

Audited by: J-F Date: 08/12/1

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD	Work Order:	43385
Description: Ø2.500 Support	Part Number:	D2892-1
Inspection Dwg: D2892	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	20
HAAS Section								
AA	0.115	0.135		.132	.132	.132	.132	.132
AB	0.290	0.310		.310	.310	.310	.310	.310
AC	0.040	0.060		.043	.041	.041	.042	.042
AD	0.115	0.135		.126	.127	.126	.126	.126
AE	0.240	0.260		.250	.246	.248	.248	.247
AF	0.188	0.193		.190	.190	.190	.190	.190
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.130	1.138	1.131	1.143	1.140
AI	0.454	0.474		.465	.467	.467	.468	.468
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.261	.261	.261	.261	.261
AM	1.663	1.683		1.672	1.671	1.671	1.673	1.673
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: J.L Date: 08/11/26

Audited by: J.F. Date: 08/12/01

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	<u>JL</u>
B	08.04.21	Reformat	KJ/JLM	<u>JL</u>

DART AEROSPACE LTD	Work Order:	43385
Description: Ø2.500 Support	Part Number:	D2892-1
Inspection Dwg: D2892	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	3	4	5
HAAS Section								
AA	0.115	0.135		.132	.132			
AB	0.290	0.310		.310	.310			
AC	0.040	0.060		.043	.042			
AD	0.115	0.135		.126	.126			
AE	0.240	0.260		.249	.250			
AF	0.188	0.193		.190	.190			
AG	0.240	0.260		.250	.250			
AH	1.126	1.146		1.138	1.137			
AI	0.454	0.474		.468	.468			
AJ	0.240	0.260		.250	.250			
AK	0.053	0.073		.063	.063			
AL	0.257	0.262		.261	.261			
AM	1.663	1.683		1.672	1.672			
AN	0.053	0.073		.063	.063			
AO	0.022	0.042		.032	.032			
AP	2.779	2.789		2.784	2.784			
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: J-L Date: 08/11/26

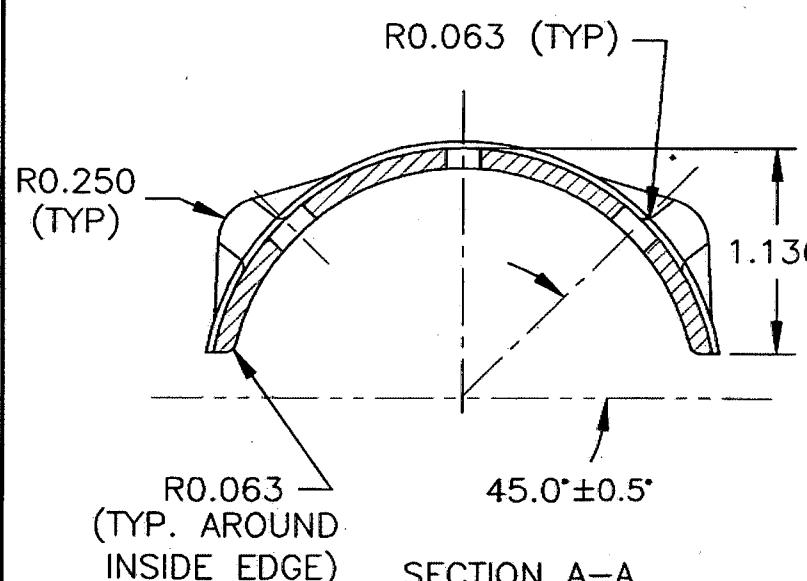
Audited by: J-F Date: 08/12/01

Prototype Approval: Date:

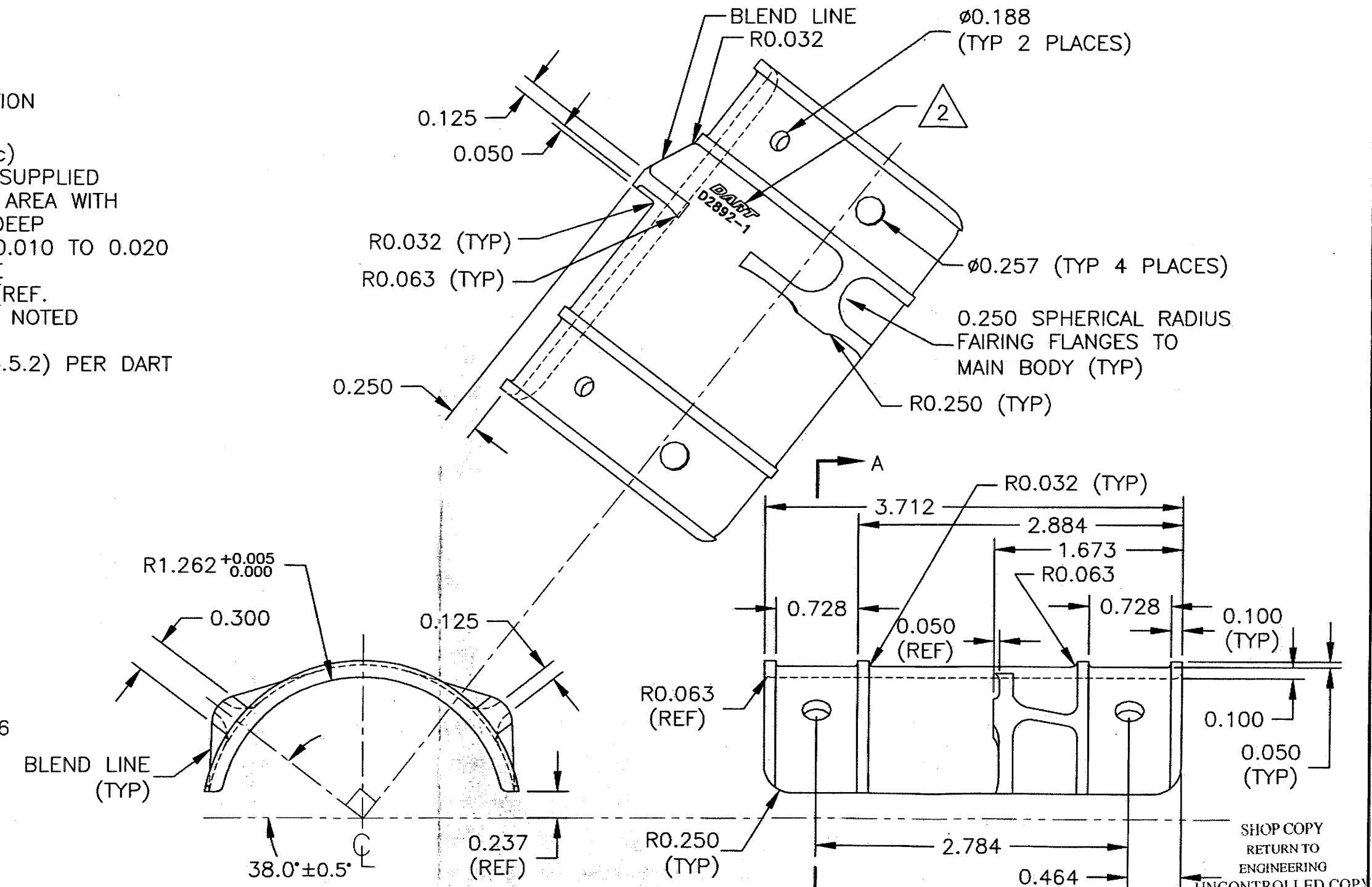
Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	JL
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D2892-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



SECTION A-A



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DART AEROSPACE LTD.

A	00.11.17	NEW ISSUE	
DESIGN <i>GP</i>	DRAWN BY <i>GP</i>	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D2892	REV. A SHEET 1 OF 1
DATE 00.11.17	TITLE Ø2.500 SUPPORT		SCALE 1:1